

Work Order ID 99163

99163

Page 1

March-28-13 12:55:25 PM

Item ID: D4576-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Horizontal Linkage Assembly, LH

Start Date: 3/27/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 3/27/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 13-04-02 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D4576

C

100 Weld per dwg A/R S.S. rod Batch: M123523 0.00

100

Large Fab

Memo

0.00

Large Fab

1- Slide (2) D3589-23 and (2) D4576-3 on D3589-1 Arm and weld D3589-13 lugs on both ends as per dwg D4576 (LUGS HAS TO BE ON A 40 DEGREE OFFSET FROM EACH OTHER, SEE SHEET 2)

*** Ensure that the 4 ARM GUIDES are on the ARM before welding both LUGS***

2-Install plates D4576-1/-9 on jig, add D3589-1 arm with arm guide D3589-3/-23 weld D3589-23 arm guides to D4576-1 and D4576-9 plates as per dwg (SEE SHEET 4 TO MAKE D4576-043/-045) use DT9825 jig and weld as per dwg D4576

① 13-05-21 8D

Pto →

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

DAS 24 9-89 Cpl 13.5.23

①

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: QA Date: 14/04/24QA Closed: KA Date: 14-6-3

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|---|------------------------------------|-----------------------------------|--|
| Work Order: <u>99163</u> Part No. <u>DY576-04</u> NCR No. <u>14-3916</u> | DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input checked="" type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input checked="" type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input checked="" type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|--------|-------|------|--|-------------------------|------------------------------------|----------------|---------------|-------------------------|
| Doc/Data <input checked="" type="checkbox"/> | B16121 | # 100 | (E1) | Due to wear in DY576-043 Pulses in the two EAP. (Bows). R.C. Design | S AS2042 13/05/24 | SCRAP + Destroy Qty 71 assembly | PD 13-05-21 | S 14/06/24 | S AS2042 13/05/24 |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | |

FAULT CATEGORY

| Landing Gear | General | Other |
|---|---|--|
| <input type="checkbox"/> Bending | <input type="checkbox"/> Bend | <input type="checkbox"/> Grain |
| <input type="checkbox"/> Centre Not Concentric to O/S | <input type="checkbox"/> BOM/Route | <input type="checkbox"/> Hardware |
| <input type="checkbox"/> Cracks | <input type="checkbox"/> Broken/Damaged | <input type="checkbox"/> Inspection Incomplete |
| <input type="checkbox"/> Crushed/Crimped | <input type="checkbox"/> Burrs | <input type="checkbox"/> Instructions Incomplete/Unclear |
| <input type="checkbox"/> Cuffs | <input type="checkbox"/> Contamination | <input type="checkbox"/> Maintenance |
| <input type="checkbox"/> Heat Treat | <input type="checkbox"/> Countersink | <input type="checkbox"/> Mislabeled |
| <input type="checkbox"/> Inspection Strip in Tube | <input type="checkbox"/> Cut Too Short | <input type="checkbox"/> Misread |
| <input type="checkbox"/> Ripples in Bend | <input type="checkbox"/> Drill Holes | <input type="checkbox"/> Offset |
| <input type="checkbox"/> Torque Waves in Extrusion | <input type="checkbox"/> Drawing | <input type="checkbox"/> Out of Calibration |
| <input type="checkbox"/> Turning Sequence | <input type="checkbox"/> Finish | <input type="checkbox"/> Out of Sequence |
| <input type="checkbox"/> Wave/Twist in Tube | <input type="checkbox"/> Folio | <input type="checkbox"/> Outside Dimensions |
| | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <u>R.C. Design</u> |
| | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

Work Order ID 99163

99163

Page 2

March-28-13 12:55:25 PM

Item ID: D4576-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Horizontal Linkage Assembly, LH

Start Date: 3/27/13 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 3/27/13 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 130 | | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | 1- Assemble as per dwg | | | | | | | | |
| 140 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

DAS
24
9-89
135.23

1x

FF 14-05-28

DAS
27
9-89
14/5/29

1

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | |
|--|-------------|-------------|------------|---|--------------------------|---------------------------|------------------------|---------------------|---------------------|--|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION <div style="display: flex; justify-content: space-around;"> <div style="text-align: right;"> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> </div> <div style="text-align: right;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div style="text-align: right;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div style="text-align: right;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div style="text-align: right;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | | |
| Doc/Data | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | |
| Material | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | |
| Other | | | | | | | | | | | | |
| Process | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | |
| Training | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | |

| FAULT CATEGORY | | | | | | | | | | | | |
|---|--|--|---|--|--|---|--|--|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | |

99163

March-28-13 12:55:25 PM

N900040100

Stop *NS2*

Stop *NR2*

[illegible]

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | |
|--|-------------|-------------|------------|--|--------------------------|---------------------------|------------------------|---------------------|---------------------|--|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update </div> <div style="text-align: center;"> <input type="checkbox"/> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab </div> <div style="text-align: center;"> <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite </div> <div style="text-align: center;"> <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier </div> <div style="text-align: center;"> <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other </div> </div> | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | | |
| Doc/Data | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | |
| Material | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | |
| Other | | | | | | | | | | | | |
| Process | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | |
| Training | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | |

| FAULT CATEGORY | | | | | | | | | | | | |
|---|--|--|---|--|--|---|--|--|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | |

Picklist Print

March-28-13 12:55:24 PM

Page 1

Work Order ID: 99163

Parent Item: D4576-041

Parent Item Name: Horizontal Linkage Assembly, LH

Start Date: 3/27/13

Required Date: 3/27/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.01.11 new issue DD verf: JFS
IPP REV:C 12.10.15 as per dwg rev.C DD VERF:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| <u>D3589-1</u> ARM | | Manufactured | No | | | 100 | Each | 5.0000 | 1 | 2 | | 13-05-21 | PD |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA002 | | 5 | | | | | | | |
| | | | | 77694 | | 1 | | | | | | | |
| | | | | 88548 | | 4 | | | | | | | |
| <u>D3589-13</u> LUG | | Manufactured | No | | | 100 | Each | 16.0000 | 2 | 4 | | 13-05-21 | PD |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA002 | | 16 | | | | | | | |
| | | | | 92178 | | 16 | | | | | | | |
| D4530-041 ✓ Latch Roller Assembly | | Manufactured | No | | | 130 | Each | 3.0000 | 1 | 2 | | SA 17/06/18 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | GA | | 3 | | | | | | | |
| | | | | 97654 | | 3 | | | | | | | |
| <u>D4576-3</u> ✓ Stop Collar | | Manufactured | No | | | 100 | Each | 8.0000 | 2 | 4 | | 13-05-21 | PD |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | CA | | 4 | | | | | | | |
| | | | | 96527 | | 4 | | | | | | | |
| | | | | WA005 | | 4 | | | | | | | |
| | | | | 79848 | | 4 | | | | | | | |
| D4576-11 ✓ Link | | Manufactured | No | | | 130 | Each | 0.0000 | 2 | 4 | | FF 14-05-20 | |

B 114474

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | |
|--|------|------|-----|---|----------------------|---|----------------|--------------|--------------|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | |

| FAULT CATEGORY | | | | | | | | | | | |
|---|--|--|---|--|--|---|--|--|--|--|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

Picklist Print

March-28-13 12:55:24 PM

Page 2

Work Order ID: 99163

Parent Item: D4576-041

Parent Item Name: Horizontal Linkage Assembly, LH

Start Date: 3/27/13

Required Date: 3/27/13

Start Qty: 2.00

Required Qty: 2.00

D3589-23

Arm Guide

Manufactured No

100 Each 21.0000

2

4

13-05-21 PD

Location

Loc Qty

Loc Code

WA002

21

91541

1

92133

20

X 2 4

D4576-1

Aft Plate

Manufactured No

100 Each 3.0000

1

2

13-05-21 PD

Location

Loc Qty

Loc Code

CA

3

96099

3

2 2

D4576-9

Fwd Plate, LH

Manufactured No

100 Each 9.0000

1

2

13-05-21 PD

Location

Loc Qty

Loc Code

ST114

9

96100

9

2 2

D4576-5

Fwd Plate Guide

Manufactured No

100 Each 3.0000

1

2

13-05-21 PD

Location

Loc Qty

Loc Code

CA

3

96939

3

2

D4576-047

Roller Shaft Weldment

Manufactured No

130 Each 1.0000

1

2

FF 14-05-28

Location

Loc Qty

Loc Code

CA

1

95990

1

1

AN960JD6

Washer

NAS1149DN632J

Purchased No

130 Each 0.0000

3

6

FF 14-05-28

4 M125646 (3x)

March-28-13 12:55:25 PM

Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | |
|--|------|------|-----|---|-------------------|---|-------------|--------------|--------------|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | |

| FAULT CATEGORY | | | |
|---|---|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

Picklist Print

Page 3

March-28-13 12:55:25 PM

Work Order ID: 99163

Parent Item: D4576-041

Parent Item Name: Horizontal Linkage Assembly, LH

Start Date: 3/27/13

Required Date: 3/27/13

Start Qty: 2.00

Required Qty: 2.00

AN960JD4 Washer Purchased No

130 Each 1,137.0000 4 8

FF 14-05-28

NAS1149DN432I 1121444

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST504 | 1137 | |
| 11735 | 722 | |
| 7636 | 415 | |

MS16562-193 Spring Pin Purchased No

130 Each 98.0000 1 2

FF 14-05-28

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST331 | 98 | |
| 120229 | 98 | |

MS20392-1C7 Pin Purchased No

130 Each 15.0000 2 4

FF 14-05-28

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST333 | 15 | |
| 120521 | 9 | |
| 123348 | 6 | |

MS24665-1010 COTTER PIN Purchased No

130 Each 305.0000 2 4

FF 14-05-28

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST323 | 305 | |
| 108335 | 200 | |
| 114405 | 105 | |

MS21043-06 Hex Nut, Self Locking Purchased No

130 Each 33.0000 1 2

FF 14-05-28

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST315 | 33 | |
| 120242 | 33 | |

h-28-13 12:55:25 PM

Shop Packet Print

Page 3

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

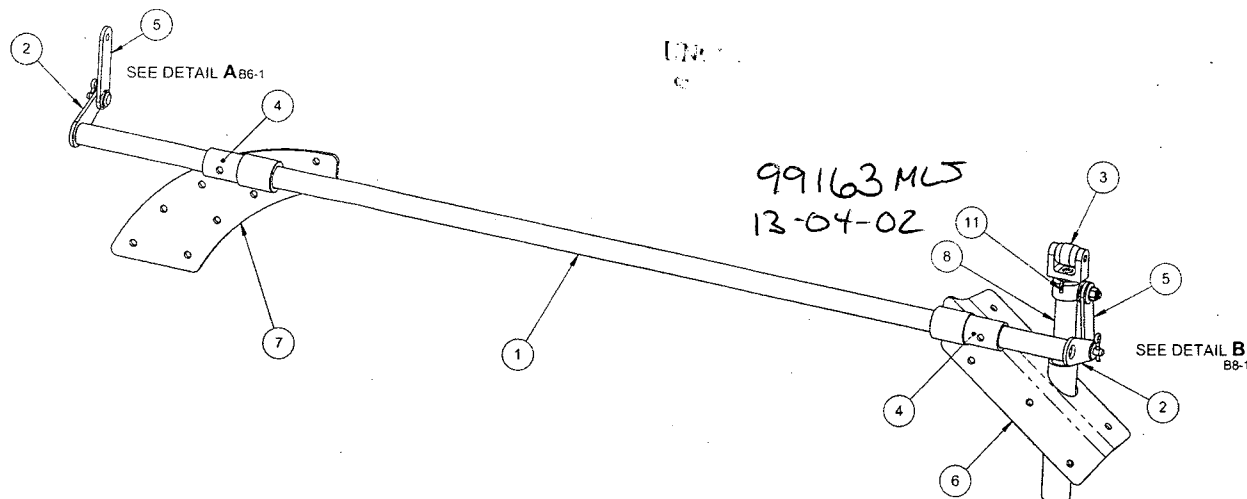
DQA: _____ Date: _____

QA Closed: _____ Date: _____

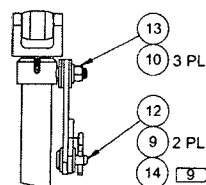
| | | | | | | | | | | |
|--|------|------|-----|---|----------------------|---|----------------|--------------|--------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | |

| FAULT CATEGORY | | | | |
|---|---|---|--|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

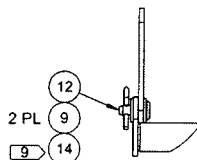
| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|--------------|------------------------------|
| | X | D4576-041 | HORIZONTAL LINKAGE ASSY (LH) |
| 1 | 1 | D3589-1 | ARM |
| 2 | 2 | D3589-13 | LUG |
| 3 | 1 | D4530-041 | LATCH ROLLER |
| 4 | 2 | D4576-3 | STOP COLLAR |
| 5 | 2 | D4576-11 | LINK |
| 6 | 1 | D4576-043 | FORWARD PLATE WELDMENT (LH) |
| 7 | 1 | D4576-045 | AFT PLATE WELDMENT (LH) |
| 8 | 1 | D4576-047 | ROLLER SHAFT WELDMENT |
| 9 | 4 | AN960JD4 | WASHER, #4 |
| 10 | 3 | AN960JD6 | WASHER, #6 |
| 11 | 1 | MS16562-193 | SPRING PIN |
| 12 | 2 | MS20392-1C7 | PIN |
| 13 | 1 | MS21043-06 | HEX NUT, SELF LOCKING, #6 |
| 14 | 2 | MS24665-1010 | COTTER PIN |



D4576-041 HORIZONTAL LINKAGE ASSY (LH)



DETAIL B C1-1



DETAIL A D5-1

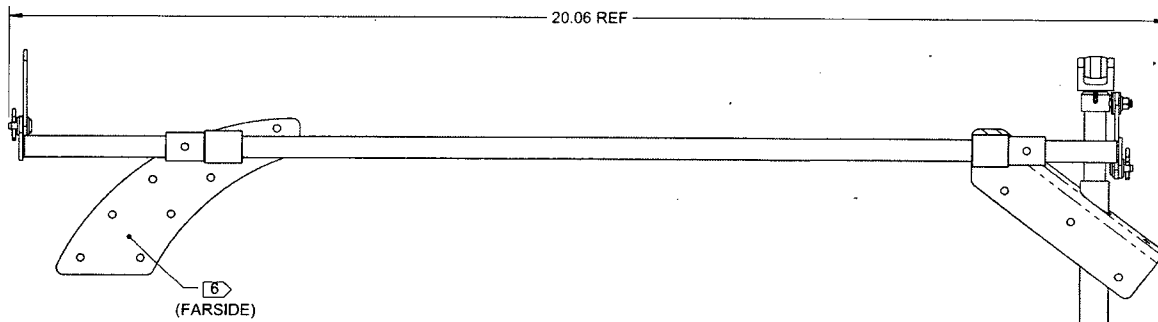
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.9 lbs
- 8) WELDING: PER DART QSI 004

RELEASED
2012-09-26

| | | | |
|------------|--|--|---------------|
| REV. | DESCRIPTION | BY | DATE |
| C | SHT 11, -10 & -9 REDESIGNED, MULTIPLE VIEWS UPDATED ACCORDINGLY. SHT 4 & 5 D3589-3 REPLACED WITH D3589-23. | AJS | 12.09.11 |
| B | ADDED (RH) VERSION D4576-042; ADDED D4576-047 WELDMENT, D4576-11 CHANGES | RP | 12.04.17 |
| A | NEW ISSUE | RP | 12.02.24 |
| DESIGN | RP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RP | | |
| CHECKED | AP | DRAWING NO. | REV. C |
| MFG. APPR. | <i>[Signature]</i> | D4576 | SHEET 1 OF 12 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | HORIZONTAL LINKAGE ASSY | NTS |
| DATE | 12.09.11 | COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

99163



D4576-041 HORIZONTAL LINKAGE ASSY (LH)

DETAIL C
C3-2
D7-2
WELDING (ITEMS 1 & 2)

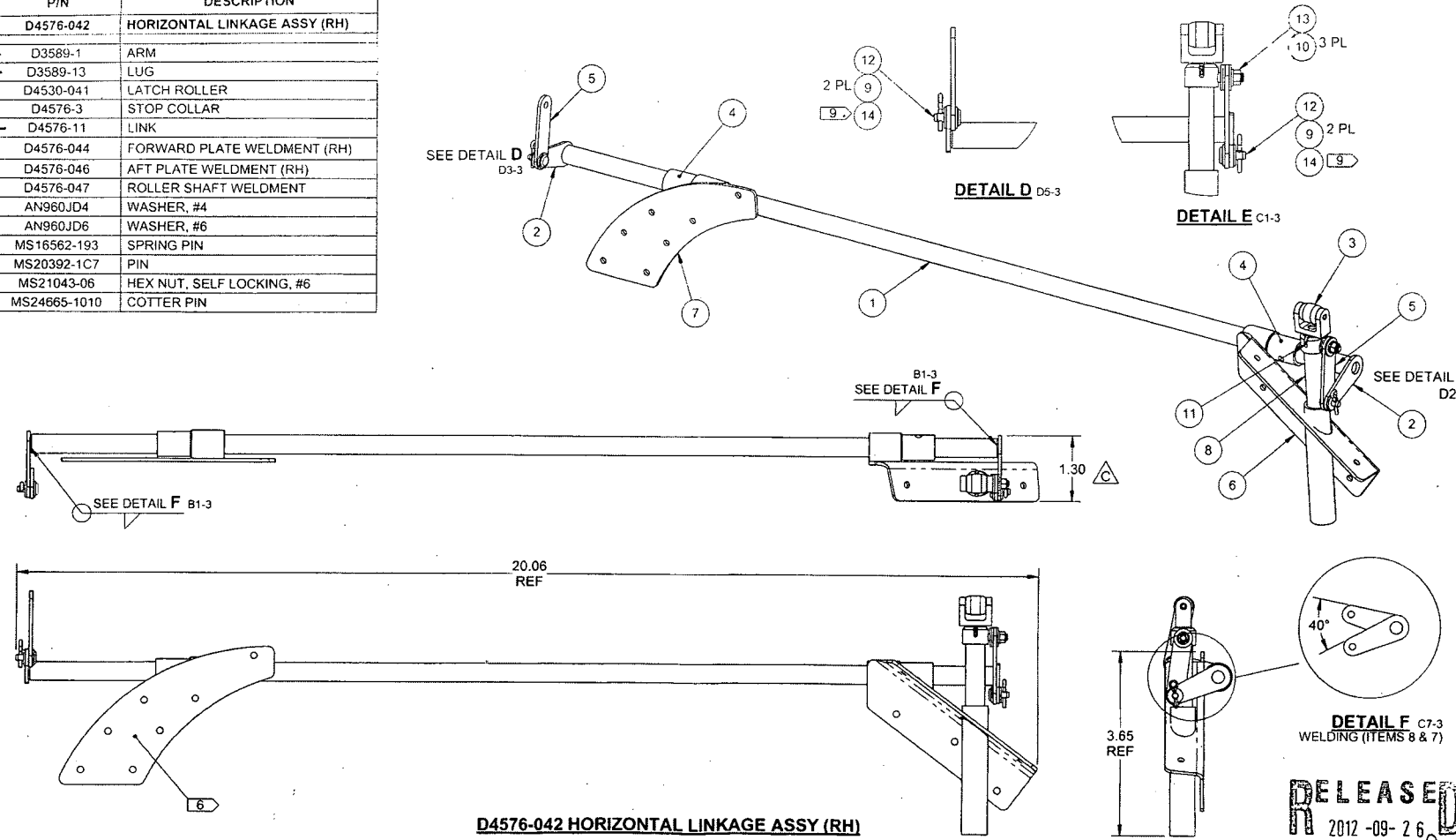
RELEASED
2012-09-26
W

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER DART QSI 044 6.1
 - 7) WEIGHT: 0.9 lbs
 - 8) WELDING: PER DART QSI 004
 - 9) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

| | | | |
|------------|--------------------|--|---------------|
| DESIGN | RP | DART AEROSPACE LTD | |
| DRAWN | RP | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AP | DRAWING NO. | REV. C |
| MFG. APPR. | <i>[Signature]</i> | D4576 | SHEET 2 OF 12 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | HORIZONTAL LINKAGE ASSY | NTS |
| DATE | 12.09.11 | COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

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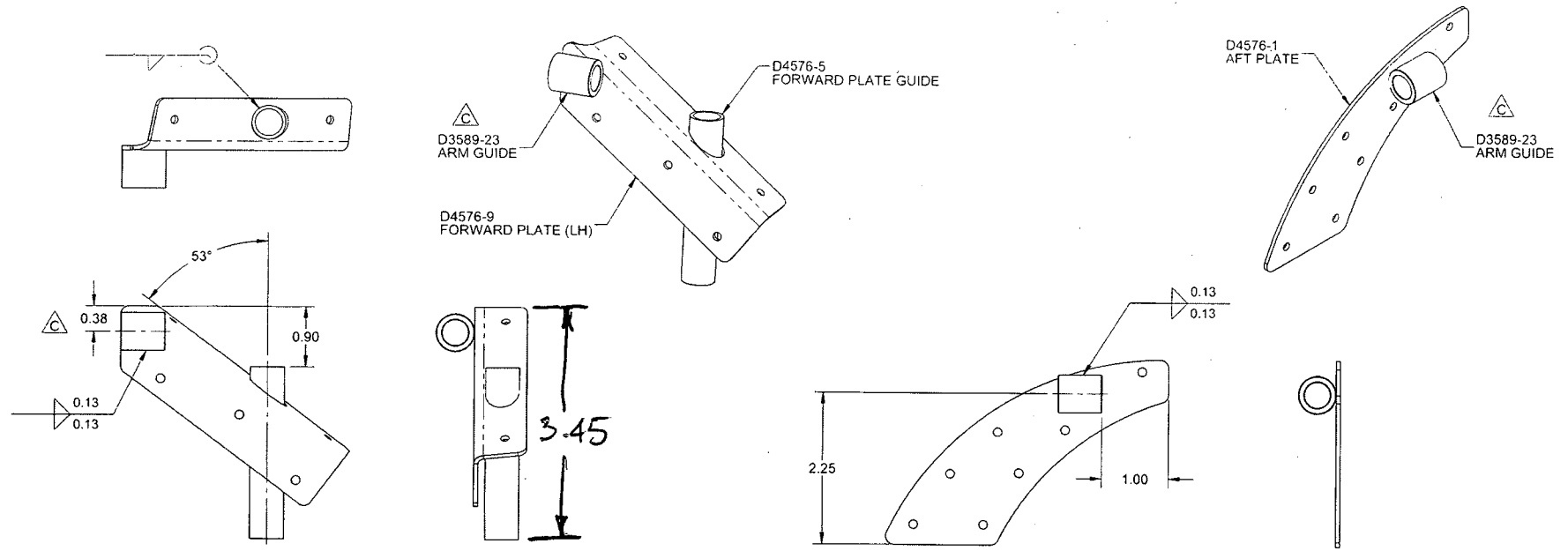
| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|--------------|------------------------------|
| | 042 | | |
| | X | D4576-042 | HORIZONTAL LINKAGE ASSY (RH) |
| 1 | 1 | D3589-1 | ARM |
| 2 | 2 | D3589-13 | LUG |
| 3 | 1 | D4530-041 | LATCH ROLLER |
| 4 | 2 | D4576-3 | STOP COLLAR |
| 5 | 2 | D4576-11 | LINK |
| 6 | 1 | D4576-044 | FORWARD PLATE WELDMENT (RH) |
| 7 | 1 | D4576-046 | AFT PLATE WELDMENT (RH) |
| 8 | 1 | D4576-047 | ROLLER SHAFT WELDMENT |
| 9 | 4 | AN960JD4 | WASHER, #4 |
| 10 | 3 | AN960JD6 | WASHER, #6 |
| 11 | 1 | MS16562-193 | SPRING PIN |
| 12 | 2 | MS20392-1C7 | PIN |
| 13 | 1 | MS21043-06 | HEX NUT, SELF LOCKING, #6 |
| 14 | 2 | MS24665-1010 | COTTER PIN |



NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER DART QSI 044 6.1
7) WEIGHT: 0.9 lbs
8) WELDING: PER DART QSI 004
9) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

| | | | |
|------------|----------|---|---------------|
| DESIGN | RP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | REV. C |
| DRAWN | RP | | |
| CHECKED | AP | DRAWING NO. D4576 | SHEET 3 OF 12 |
| MFG. APPR. | | TITLE | SCALE |
| APPROVED | | HORIZONTAL LINKAGE ASSY | NTS |
| DE APPR. | | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. USE IS LIMITED TO THE EXPRESS OR IMPLIED SCOPE OF THE CONTRACT. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DATE | 12.09.11 | | |

99163



D4576-043 FORWARD PLATE WELDMENT (LH)

| ITEM | QTY -043 | P/N | DESCRIPTION |
|------|-------------|----------|---------------------|
| 1 | 1 | D3589-23 | ARM GUIDE |
| 2 | 1 | D4576-5 | FORWARD PLATE GUIDE |
| 3 | 1 | D4576-9 | FORWARD PLATE (LH) |

D4576-045 AFT PLATE WELDMENT (LH)

| ITEM | QTY -045 | P/N | DESCRIPTION |
|------|-------------|----------|-------------|
| 1 | 1 | D3589-23 | ARM GUIDE |
| 2 | 1 | D4576-1 | AFT PLATE |

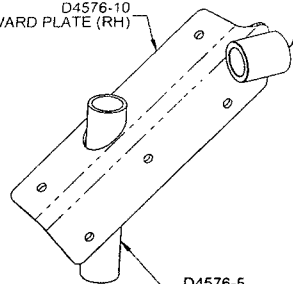
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT:
 - D4576-043 = 0.19 lbs
 - D4576-045 = 0.16 lbs
 - 8) WELDING: PER DART QSI 004

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2012-09-26

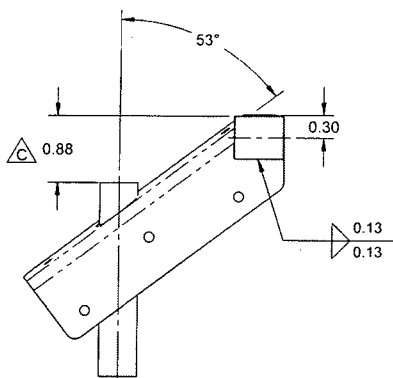
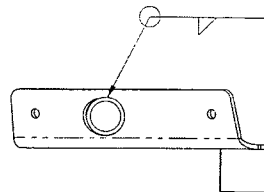
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| DESIGN | RP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| DRAWN | RF | |
| CHECKED | AP | DRAWING NO. REV. C |
| MFG. APPR. | DS | D4576 SHEET 4 OF 12 |
| APPROVED | 12 | TITLE SCALE |
| DE APPR. | 12 | HORIZONTAL LINKAGE ASSY NTS |
| DATE | 12.09.11 | COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO PART IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |

99163

D4576-10 FORWARD PLATE (RH)
D3589-23 ARM GUIDE



D4576-5 FORWARD PLATE GUIDE



D4576-044 FORWARD PLATE WELDMENT (RH)

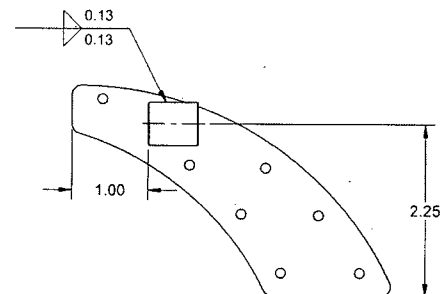
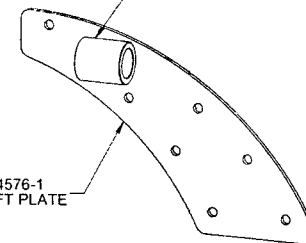
| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|----------|---------------------|
| 1 | 1 | D3589-23 | ARM GUIDE |
| 2 | 1 | D4576-5 | FORWARD PLATE GUIDE |
| 3 | 1 | D4576-10 | FORWARD PLATE (RH) |

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT:
 - D4576-044 = 0.19 lbs
 - D4576-046 = 0.16 lbs
- 8) WELDING: PER DART QSI 004

D3589-23 ARM GUIDE

D4576-1 AFT PLATE



D4576-046 AFT PLATE WELDMENT (RH)

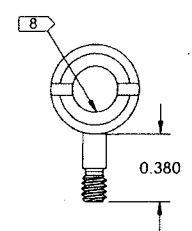
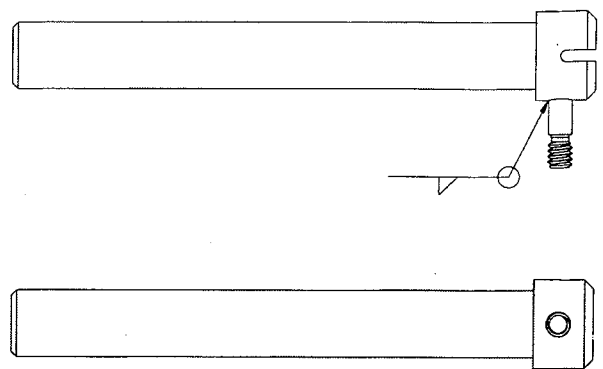
| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|----------|-------------|
| 1 | 1 | D3589-23 | ARM GUIDE |
| 2 | 1 | D4576-1 | AFT PLATE |

RELEASED
2012-09-26

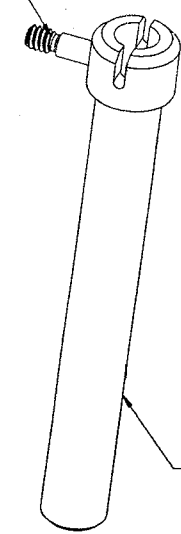
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| DESIGN | RP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RP | | |
| CHECKED | AP | DRAWING NO. | REV. C |
| MFG. APPR. | AP | D4576 | SHEET 5 OF 12 |
| APPROVED | AP | TITLE | SCALE |
| DE APPR. | AP | HORIZONTAL LINKAGE ASSY | NTS |
| DATE | 12.09.11 | COPYRIGHT © 2012 BY DART AEROSPACE LTD | |

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99163



D4576-13
THREADED STUD



D4576-7
LATCH SHAFT

D4576-047 ROLLER SHAFT WELDMENT

| ITEM | QTY -047 | P/N | DESCRIPTION |
|------|-------------|----------|---------------|
| 1 | 1 | D4576-7 | LATCH SHAFT |
| 2 | 1 | D4576-13 | THREADED STUD |

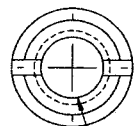
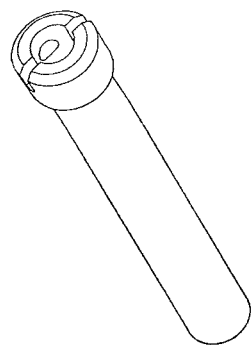
RELEASED
2012-09-26

NOTES:

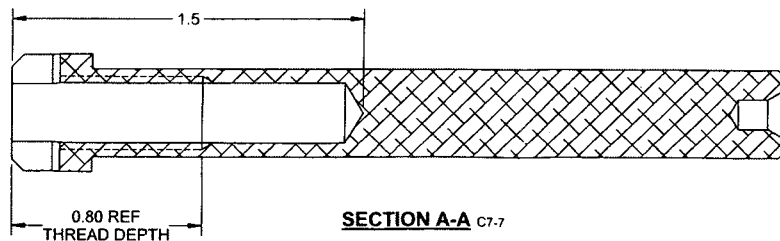
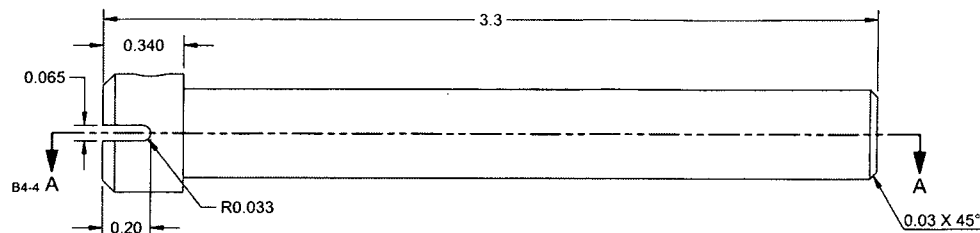
- 1) MATERIAL: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: - D4576-047 = 0.07 lbs
- D4576-13 = 0.01 lbs
- 8) THREADED STUD NOT TO INTERFERE WITH 5/16-18 THREAD IN LATCH SHAFT
- 9) WELDING: PER DART QSI 004

| | | | |
|------------|----------|---|---------------|
| DESIGN | RP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RP | | |
| CHECKED | A.P. | DRAWING NO. | REV. C |
| MFG. APPR. | | D4576 | SHEET 6 OF 12 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | HORIZONTAL LINKAGE ASSY | NTS |
| DATE | 12.09.11 | <small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

99163

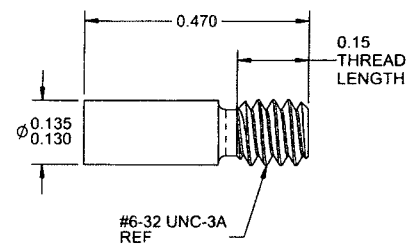
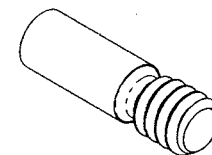


5/16-18 UNC-2B
0.80 DP



SECTION A-A C7-7

ACCEPTABLE TO
CENTER DRILL
MAX #3





8 D4576-13 THREADED STUD

RELEASED
2012-09-26

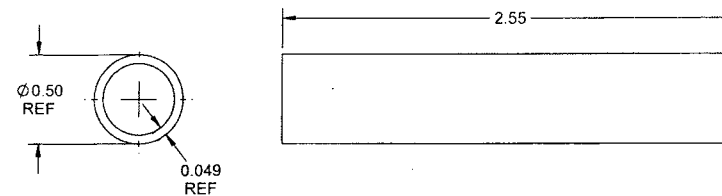
NOTES:

- 1) MATERIAL: AISI 304/316 SS ROUND BAR PER ASTM A276
REF DART SPEC M304R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.07 lbs
- 8) MAY BE FABRICATED FROM MCMASTER P/N 97345A458

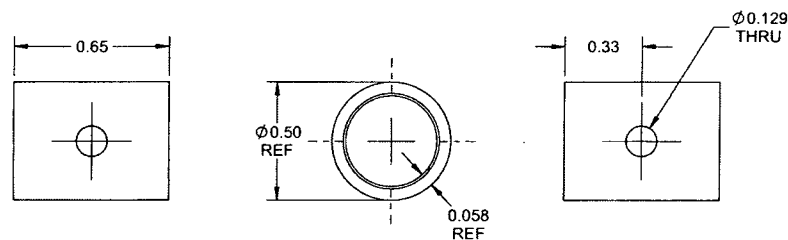
D4576-7 LATCH SHAFT

| | | | |
|------------|---|--|---------------|
| DESIGN | RP | DART AEROSPACE LTD | |
| DRAWN | RP | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | A.R. | DRAWING NO. D4576 | REV. C |
| MFG. APPR. |  | | SHEET 7 OF 12 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. | | HORIZONTAL LINKAGE ASSY | NTS |
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99163



D4576-5 FORWARD PLATE GUIDE



D4576-3 STOP COLLAR

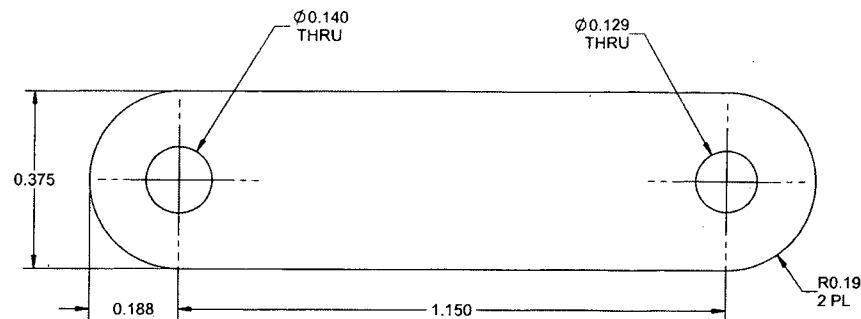
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM A269
D4576-3: 0.500 O.D. X 0.058 WALL
REF. DART SPEC M304TR0.500W.058
D4576-5: 0.500 O.D. X 0.049 WALL
REF. DART SPEC M304TR0.500W.049
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: - D4576-3 = 0.01 lbs ea.
- D4576-5 = 0.06 lbs

RELEASE
2012-09-26
ND

| | | | |
|------------|----------|--|---------------|
| DESIGN | RP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RP | | |
| CHECKED | A.P. | DRAWING NO. D4576 | REV. C |
| MFG. APPR. | | | SHEET 8 OF 12 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | HORIZONTAL LINKAGE ASSY | NTS |
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D4576-11 LINK

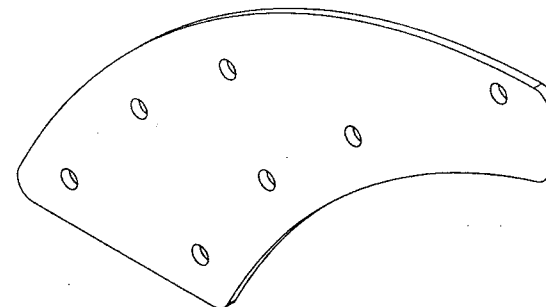
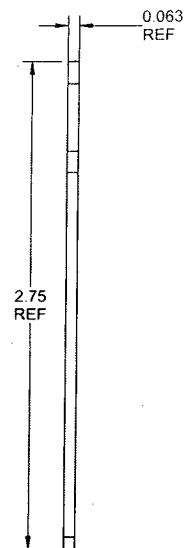
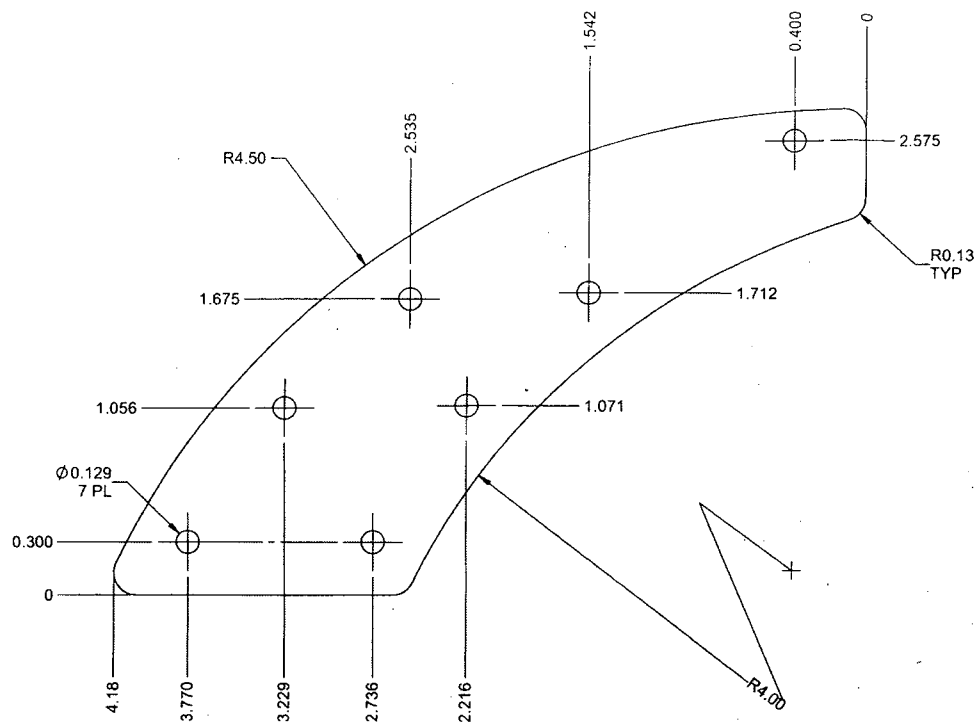
RELEASED
2012-08-16
JWP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, ANNEALED, 2B FINISH.
16 GAUGE (0.063 THICK)
PER AMS 5513 OR AMS 5524, OR MIL-S-5059
REF. DART SPEC M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: <0.01 lbs

| | | | |
|------------|-------------|---|--------|
| DESIGN | RP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RP | | |
| CHECKED | A.P. | DRAWING NO. D4576 | REV. C |
| MFG. APPR. | [Signature] | SHEET 9 OF 12 | |
| APPROVED | [Signature] | TITLE | SCALE |
| DE APPR. | [Signature] | HORIZONTAL LINKAGE ASSY | NTS |
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D4576-1 AFT PLATE

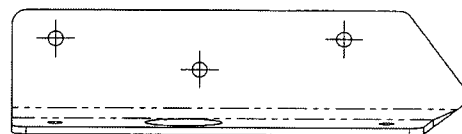
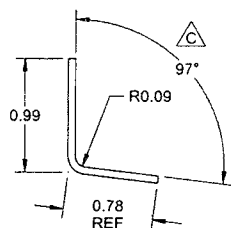
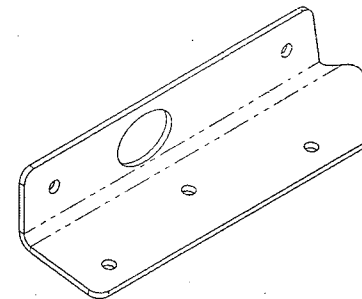
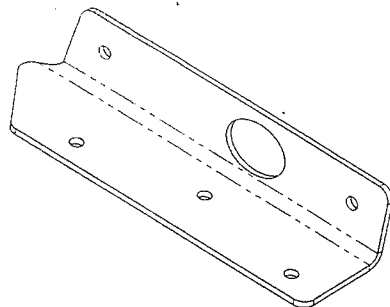
RELEASED
2012-09-26
JND

NOTES:

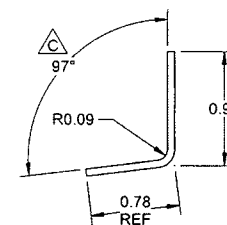
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, ANNEALED, 2B FINISH.
16 GAUGE (0.063 THICK)
PER AMS 5513 OR AMS 5524, OR MIL-S-5059
REF. DART SPEC M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.09 lbs

| | | | |
|------------|----------|--|----------------|
| DESIGN | RP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RP | | |
| CHECKED | A.P. | DRAWING NO. D4576 | REV. C |
| MFG. APPR. | | | SHEET 10 OF 12 |
| APPROVED | JND | TITLE | SCALE |
| DE APPR. | | HORIZONTAL LINKAGE ASSY | NTS |
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D4576-10 FORWARD PLATE (RH)
(MADE FROM D4576-9F)



D4576-9 FORWARD PLATE (LH)
(MADE FROM D4576-9F)

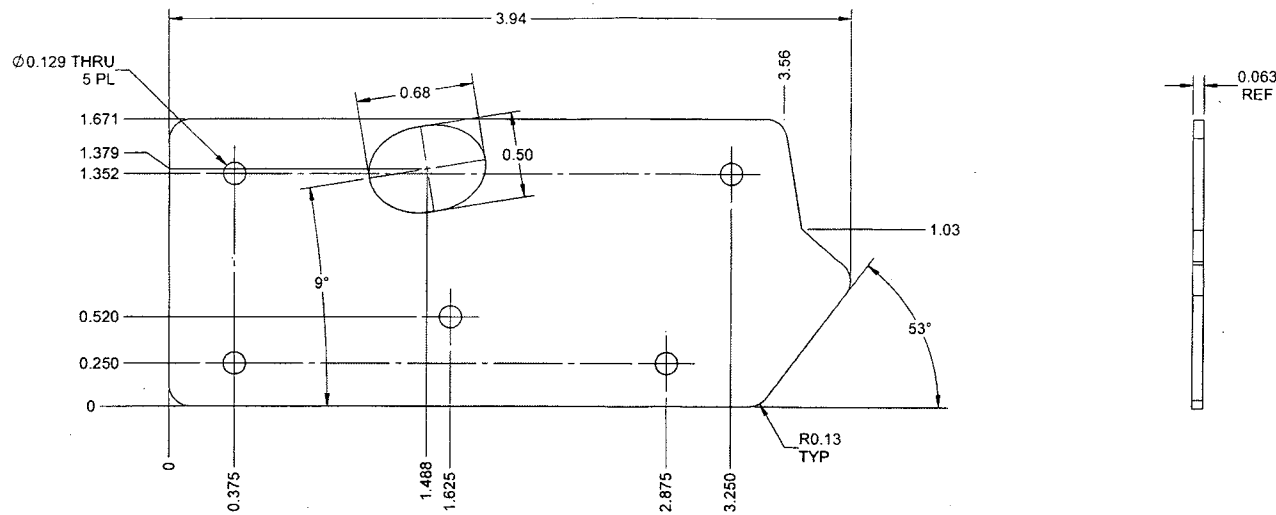
RELEASE
R 2012-09-26
U

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.11 lbs

| | | | |
|------------|----------|---|----------------|
| DESIGN | RP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RP | | |
| CHECKED | AP | DRAWING NO. | REV. C |
| MFG. APPR. | IS | D4576 | SHEET 11 OF 12 |
| APPROVED | AP | TITLE | SCALE |
| DE APPR. | AP | HORIZONTAL LINKAGE ASSY | NTS |
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


99163



D4576-9F FORWARD PLATE 
(FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, ANNEALED, 2B FINISH.
16 GAUGE (0.063 THICK)
PER AMS 5513 OR AMS 5524, OR MIL-S-5059
REF. DART SPEC M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.11 lbs

| | | | |
|--|---|--|----------------|
| DESIGN | RP | DART AEROSPACE LTD | |
| DRAWN | RP | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AP | DRAWING NO. | REV. C |
| MFG. APPR. |  | D4576 | SHEET 12 OF 12 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | HORIZONTAL LINKAGE ASSY | NTS |
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